

# Work Order ID 55050



Page 1

January 5, 2010 1:51:30 PM

Item ID: D3706-1

Accept



Setup Start



Revision ID:

Item Name: Lock Bracket

Stop



Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:



Date: 10-1-05 Tooling:

Date:

Raw Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr								
D3706	Rev A								
100									
	BAND SAW		0.00						
Bandsaw		Memo 3.625	0.00						
Jeaspa Bandsaw		Cut blank 3.5" long							

110		CONVENTIONAL MILLING MACHINE	0.00						
		Memo	0.00						
Conventional Milling Machine		1- Mill as per dwg D3706 2-Deburr as per dwg D3706							

HAAS #1		10-01-11	0.00						
120		QC2- Inspect parts off machine FAI/FAIB	0.00						
QC		Memo	0.00						

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 55050**

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January 5, 2010 1:51:30 PM

Item ID: D3706-1

Accept



Setup Start



Revision ID:

Item Name: Lock Bracket

Stop



Start Date: 05/01/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 15/01/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC8- Inspect parts - second check

0.00

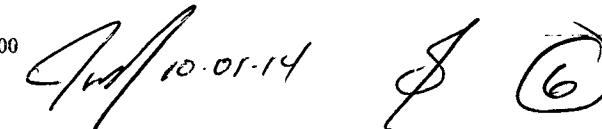


QC

Quality Control

Memo

0.00



140

Identify as per dwg & Stock Location: 5784

0.00



Packaging

Packaging

Memo

0.00



150

QC21- Final Inspection - Work Order Release

0.00

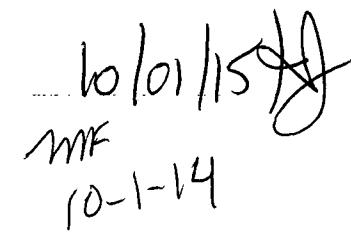


QC

Quality Control

Memo

0.00



W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Page 1

January 5, 2010 1:51:34 PM

Work Order ID: 55050



Parent Item: D3706-1



Parent Item Name: Lock Bracket

Start Date: 05/01/2010

Required Date: 15/01/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B0.750X01.50 0		Purchased		No			f	15.6756	1.8000			

6061-T6 Bar .750 X 1.50



Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT

15.6755998

110167

15.6755998

1.8410 ft A 10/01/13

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	55050
Description: LOCK BRACKET	Part Number:	D3706-1
Inspection Dwg: D3706 Rev: A		Page 1 of 1

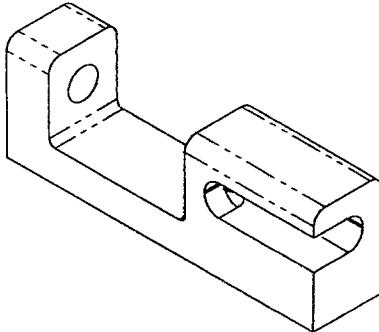
## FIRST ARTICLE INSPECTION CHECKLIST

## X First Article      Prototype

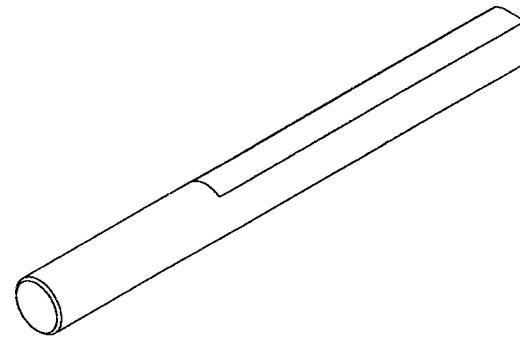
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Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

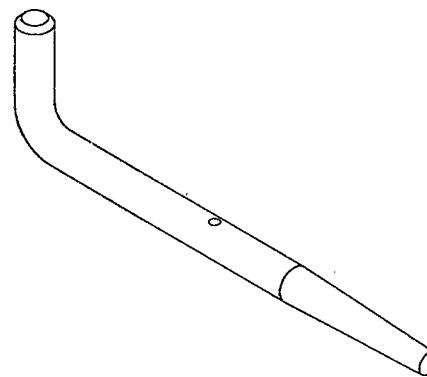
8 7 6 5 4 3 2 1



D3706-1 LOCK BRACKET



D3706-3 GUIDE



D3706-5 PIN

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 55050

PL 10-1-05

RELEASED  
07/01/DSM

A	NEW ISSUE	MS	06.05.26
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>15</i>		
DRAWN	<i>AS</i>		
CHECKED	<i>PL</i>		
MFG. APPR.	<i>PL</i>		
APPROVED	<i>PL</i>		
DE APPR.	<i>PL</i>		
DATE	08.05.26	SCALE	NTS
		DART AEROSPACE LTD	
		HAWKESBURY, ONTARIO, CANADA	
		DRAWING NO.	REV. A
		D3706	SHEET 1 OF 4
		TITLE	
		INSTRUMENT PANEL LOCK	
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D

C

B

A

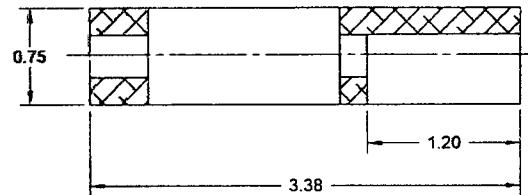
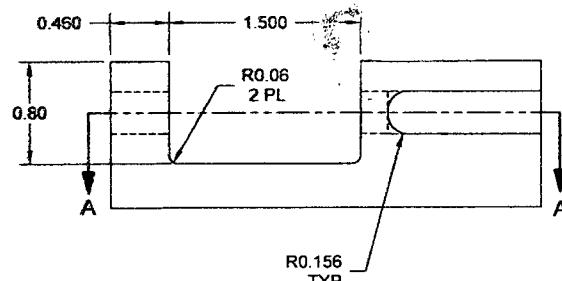
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

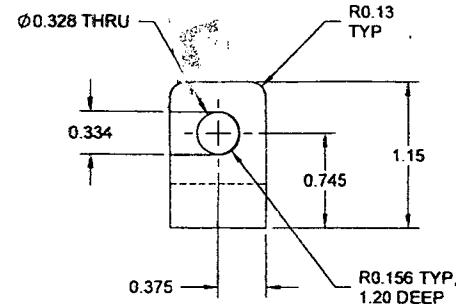
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION A-A

D3706-1 LOCK BRACKETD3706-1 NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
(REF. DART SPEC. M6061T6B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.17 lbs

DESIGN	11	DART AEROSPACE LTD
DRAWN	11	HAWKESBURY, ONTARIO, CANADA
CHECKED	11	DRAWING NO.
MFG. APPR.	11	REV. A
APPROVED	11	D3706 SHEET 2 OF 4
DE APPR.	11	TITLE
DATE 08.05.26		SCALE NTS
INSTRUMENT PANEL LOCK		

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8/26/05  
410 55050

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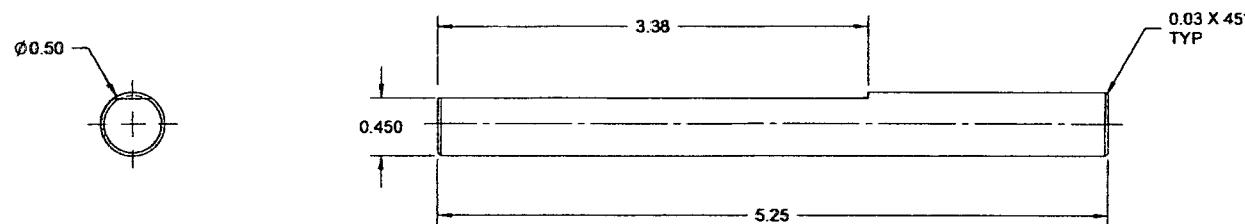
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3706-3 GUIDE

**D3706-3 GUIDE NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T651/-T6510/-T6511/-T62) ALUMINUM ROUND BAR  
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR  
PER AMS-QQ-A-200/8 (OR AMS 4160)  
REF. DART SPEC. M6061T6R0.500
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.10 lbs

RELEASED  
07/05/04

w/o 5505d

DESIGN	<i>1/2</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	<i>1/2</i>	
CHECKED	<i>1/2</i>	
MFG. APPR.	<i>1/2</i>	
APPROVED	<i>1/2</i>	
DE APPR.	<i>1/2</i>	
DATE	08.05.26	REV. A DRAWING NO. D3706 SHEET 3 OF 4 TITLE SCALE NTS INSTRUMENT PANEL LOCK

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

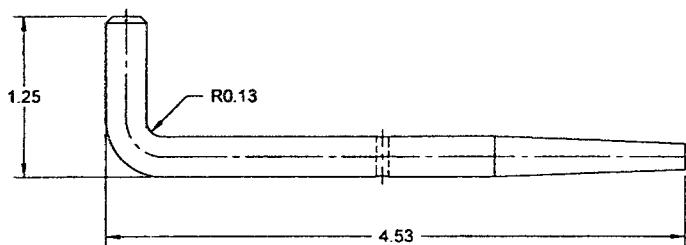
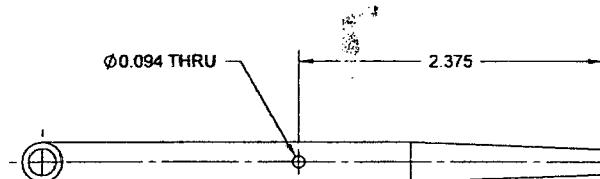
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

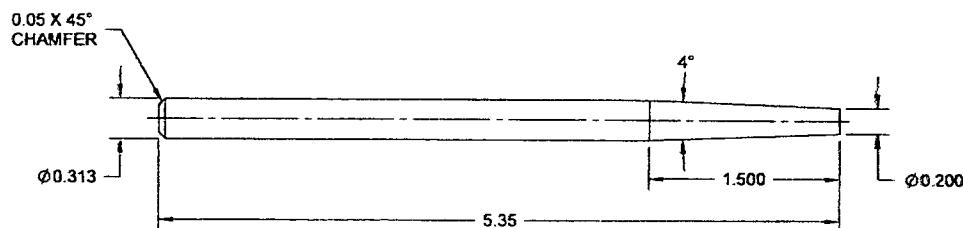
NOTE: Date & initial all entries

8 7 6 5 4 3 2 1



**D3706-5 PIN**  
(MAKE FROM D3706-5F)

**D3706-5 NOTES:**  
 1) MATERIAL: AISI 303 STAINLESS STEEL ROUND BAR  
 (REF. DART SPEC. M303R)  
 2) FINISH: NONE  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: N/A  
 7) WEIGHT: 0.11 lbs



**D3706-5F PIN**

RELEASED  
 08/05/11

w/0 55050

DESIGN		DART AEROSPACE LTD
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED		DRAWING NO.
MFG. APPR.		REV. A
APPROVED		D3706
DE APPR.		SHEET 4 OF 4
DATE	08.05.26	TITLE
		INSTRUMENT PANEL LOCK
		SCALE
		NTS

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries